



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D119-646-043
Job Sheet 173337



Part No: D119-646-043

Job Qty: 1 ea

Part Name: AW119 Replacement Skidtube with Wearpads, Float Compatible - Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/28/18

Job Tracking No:

Due Date: 3/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG IIN-D119-646 REV D, D3905-041 REV E SHEETS 1,2,5,6, 8-14 IPP RevA: New issue DD verified by:EC IPP revB 10.02.22 per PAR 09-043 EC verified by:DD IPP REVC 12.11.05 (DEOD3905-B-1)(ecn 12-675) DD verf:JLM IPP REV:D 13.03.20 per chg003 ECN13-534 DD verf:JLM IPP REV:E 15.01.19 AS PER ECN-14-628 DD verf:JLM IPP REV:F 16.11.02 chg as per D3905 revD(DEO) DD verf:JLM IPP REV:G 17.05.23 as per dwg D3905 rev.e DD verf:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/15/18	0.00	0.00	Start Up Skidtubes-1		MCN
110	Skidtubes	1 pcs		3/15/18	0.00	3.68	Skidtubes-1		MLG
120	HandFinish	1 pcs		3/15/18	0.00	1.56	HandFinish1		18-03-01
130	QC	1 pcs		3/15/18	0.00	0.00	QC7-1		MCN
140	QC	1 pcs		3/15/18	0.00	0.00	QC5		MLG
170	Skidtubes	1 pcs		3/15/18	0.00	3.68	Skidtubes-1		MLG
180	QC	1 pcs		3/15/18	0.00	0.00	QC5		MLG
190	Skidtubes	1 pcs		3/15/18	0.00	3.68	Skidtubes-1		MLG
200	QC	1 pcs		3/15/18	0.00	0.00	QC5		33 DAS
210	QC	1 pcs		3/15/18	0.00	0.00	QC10		33
220	HandFinish	1 pcs		3/15/18	0.00	1.56	HandFinish2		SA 18-3-12
230	Spray Paint	1 pcs		3/15/18	0.00	0.42	Spray Paint		CT 18-3-16
240	QC	1 pcs		3/15/18	0.00	0.00	QC14		ML 18-3-19
250	HandFinish	1 pcs		3/15/18	0.00	1.56	HandFinish4		ML 18-3-20
260	QC	1 pcs		3/15/18	0.00	0.00	QC5		ML 18-3-20
270	HandFinish	1 pcs		3/15/18	0.00	1.56	HandFinish4		ML 18-3-20
280	QC	1 pcs		3/15/18	0.00	0.00	QC5		ML 18-3-20
285	HandFinish	1 pcs		3/16/18	0.00	1.56	HandFinish3		ML 18-3-20
286	QC	1 pcs		3/16/18	0.00	0.00	QC5		33
289	QC	1 pcs		3/16/18	0.00	0.00	QC		33
295	Packaging	1 pcs		3/16/18	0.00	0.00	Packaging3-1		ML 18-3-20
300	QC21-FG	1 Ea		3/16/18	0.00	0.00	QC21		21 MAR 21 2018

Part Op 110 - 1- Bend FWD end of tube using Bender 1 and bend prog D3905 FWD per dwg D3905 (FOLIO -04) 2- Cut FWD
Descriptions: end of tube as per dwg D3905. 3- Cut AFT end of tube as per dwg D3905. 4- Buff out marks left from bending. 5- Install
drill Jig DT9480 drill X-bolt spacer pilot holes using 3/16" drill first side only. 6- 2nd side, locating from first saddle holes
use DT9861 A/B to drill 2nd side fwd saddle holes. 7- 2nd side locating from fwd saddle drill remaining crossbolt spacer
holes using DT9480 8- Drill FWD cap holes using DT8215.
170- Open FWD Saddle holes to finish size as per dwg and deburr 1-Bond web in place as per Dwg D3905 & QSI Q15.
(at 42.95" ref.) A/R Sikaflex-291 138787 Sikaflex expire date: 18-04-21 Start: 18-03-01 Time:
Finish: Time: ***** (Adhere for 12 hours) ***** 2--Bend AFT end of tube using
CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Install drop pins in crossbolt spacer holes to maintain web
position. 3- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per



Container No: S046771



Part: D119-646-043

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Serial No/Batch: S046771

Revision:

Inspector:

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Date: 03/01/16

dwg. 1- Drill Tow ring hole using DT10047. Open to finished size. 2- Open FWD & AFT cap holes per dwg. Countersink Fwd cap only as per detail "C". 3- Open crossbolt spacer holes to finished size. Drill most Fwd wearplate holes using DT9816 (15.21") 7-Debur crossbolt spacer holes as per Dwg D3905 and blow out chips from inside the tube 8- Drill holes for wearpads using DT9613 & DT 9545. **#9** **#10** **#11**

190 - NOTE: TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDLING FIXTURE, IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3905. Remember to back drill each hole before welding the other side. Use aluminum rod A/R Aluminum Rod A/R M138673 2-Grind cross bolt welds flush as per Dwg D3905. Ensure no pin hole. 3-Counterbore 5/16" x 0.750" deep as per Dwg D3905. 4- Debur & Scribe batch # on Aft end of tube. 5- Pick D2855-5 cap and transfer drill missing hole. Debur and identify cap with skidtube batch#.

200 - TEST FIT USING FIXTURE DT10091.

220 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

230 - *****AS PER DETAIL "F" NOTE 8, SHEET 8 MASK THIS AREA, DO NOT APPLY PRIMER OR PAINT***** PRIME AS PER DWG AND QSI 005 4.2 BATCH: _____ PAINT WHITE AS PER DWG AND QSI 005 4.2 BATCH: _____

250 - 1-Install inserts as per Dwg D3905.

270 - 1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 2-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: _____ 3 -Inspect for foreign objects as per QSI 024 4 -Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 5 -Install insert in D2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 _____ Sikaflex expire date: _____ 6- Install (2)D5101-041 and (1) D5101-047 as per dwg by using DT10117

289 - Photocopy bluefile & type labels per PPP D119-646-043 CHG 005

001779

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n - 1' Beam Tube 4"	1 Ea (1 ea)	90-Start up Operation	S030536
D3885-3	Float Web	1 Ea (1 ea)	170-Skidtubes	S000623
D2579	Crossbolt Spacer	2 Ea (2 ea)	190-Skidtubes	S040524
D2855-5	Cap	1 Ea (1 ea)	190-Skidtubes	S 016939
D3681-1	Spacer	8 Ea (8 ea) +1	190-Skidtubes	S019747
D3903-1	Spacer	12 Ea (12 ea)	190-Skidtubes	S031093
ALS4-1032-130	Rivnut	42 Ea (42 ea)	250-HandFinish	HA S00374
D3683-3	Insert	12 Ea (12 ea)	250-HandFinish	W10
ALS4-1032-225	Rivnut	1 Ea (1 ea)	270-HandFinish	S048375
AN3C4A	Bolt	6 Ea (6 ea)	270-HandFinish	F11138640-3
AN3C5A	Bolt	38 Ea (38 ea)	270-HandFinish	S019396
AN4C46A	Bolt	3 Ea (3 ea)	270-HandFinish	S006307
D2855-3	Cap	1 Ea (1 ea)	270-HandFinish	F153291
D3492-5	Plug	16 Ea (16 ea)	270-HandFinish	S038391
D3672-1	Washer, Phenolic	2 Ea (2 ea)	270-HandFinish	F1600374
D3672-3	Washer, Phenolic	12 Ea (12 ea)	270-HandFinish	S036137
D3847-1	Wearpad	8 Ea (8 ea)	270-HandFinish	S010633
D3847-11	Wearpad	1 Ea (1 ea)	270-HandFinish	F143449
D5101-041	Crossbolt Spacer Assembly	2 Ea (2 ea)	270-HandFinish	S000833
D5101-047	Crossbolt Spacer Assembly	1 Ea (1 ea)	270-HandFinish	
D5101-3	Insert	6 Ea (6 ea)	270-HandFinish	F158939
D5101-5	Insert	6 Ea (6 ea)	270-HandFinish	F158796
MS21043-4	Nut	3 Ea (3 ea)	270-HandFinish	S038086
MS24694-C52	Screw	2 Ea (2 ea)	270-HandFinish	
MS27039C4-08	Screw	12 Ea (12 ea)	270-HandFinish	F11137961
NAS1149C0332R	Washer	44 Ea (44 ea)	270-HandFinish	S044286
NAS1149C0463R	Washer	12 Ea (12 ea)	270-HandFinish	
NAS1611-005	O-Ring	16 Ea (16 ea)	270-HandFinish	S007809

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-1-190	1	105	0
170-Skidtubes	D3885-3	1	7	0
190-Skidtubes	D2579	2	39	0
	D2855-5	1	102	0
	D3681-1	8	359	0
	D3903-1	12	121	0
250-HandFinish	ALS4-1032-130	42	7,858	0
	D3683-3	12	219	0

270-HandFinish

ALS4-1032-225	1	993	0
AN3C4A	6	3,083	0
AN3C5A	38	751	0
AN4C46A	3	245	0
D2855-3	1	17	0
D3492-5	16	114	0
D3672-1	2	1,087	0
D3672-3	12	1,408	0
D3847-1	8	41	0
D3847-11	1	21	0
D5101-041	2	20	0
D5101-047	1	3	0
D5101-3	6	74	0
D5101-5	6	60	0
MS21043-4	3	883	0
MS24694-C52	2	77	0
MS27039C4-08	12	226	0
NAS1149C0332R	44	4,426	0
NAS1149C0463R	12	201	0
NAS1611-005	16	307	0

Part Specifications

Specifications could not be found.

Plex 2/28/18 11:37 AM Dart.lajeunesse.marie

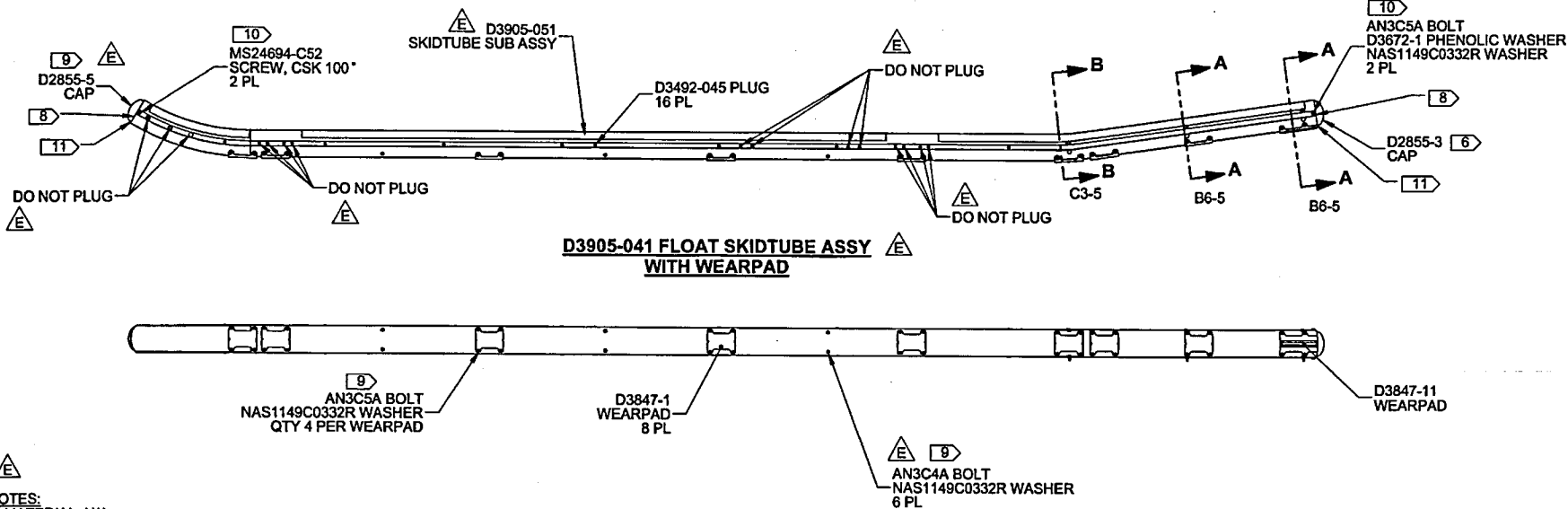


RELEASED
2017-05-08
EAN 17-519

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3905-041	SKIDTUBE ASSY
1	1	D2855-3	CAP
2	1	D2855-5	CAP
3	16	D3492-045	PLUG
4	2	D3672-1	PHENOLIC WASHER
5	8	D3847-1	WEARPAD
6	1	D3847-11	WEARPAD
7	1	D3905-051	SKIDTUBE SUB ASSEMBLY
8	2	D5101-041	CROSSBOLT SPACER ASSY
9	1	D5101-047	CROSSBOLT SPACER ASSY
10	6	D5101-3	INSERT
11	6	D5101-5	INSERT

ITEM	QTY -041	P/N	DESCRIPTION
12	1	ALS4-1032-225	INSERT
13	6	AN3C4A	BOLT
14	38	AN3C5A	BOLT
15	3	AN4C46A	BOLT
16	3	MS21043-4	NUT, SELF-LOCKING
17	2	MS24694-C52	SCREW, CSK 100°
18	44	NAS1149C0332R	WASHER
19	6	NAS1149C0416R	WASHER



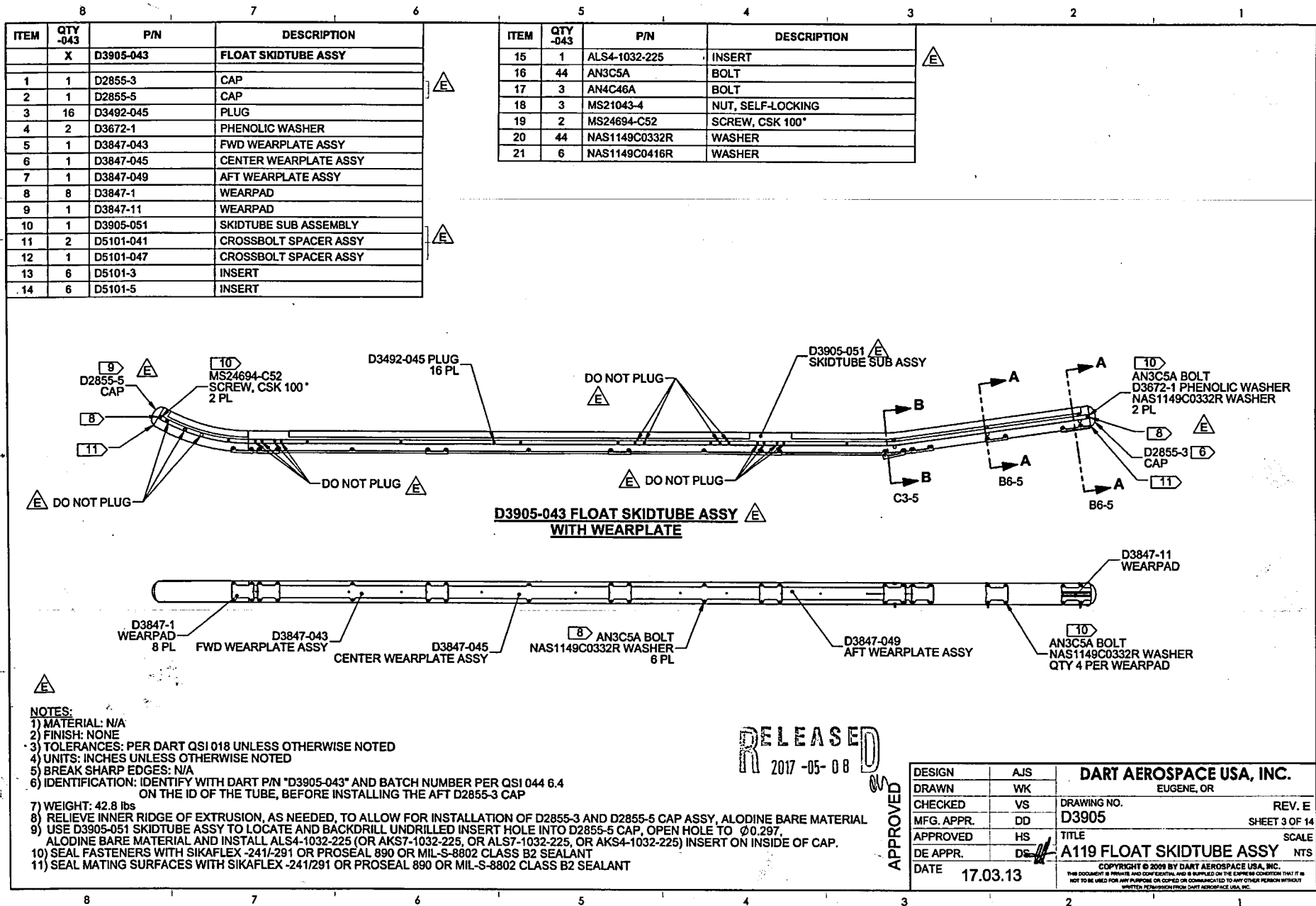
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3905-041" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 35.4 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
- 9) USE D3905-051 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP, OPEN HOLE TO $\varnothing 0.297$, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

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2017-05-08

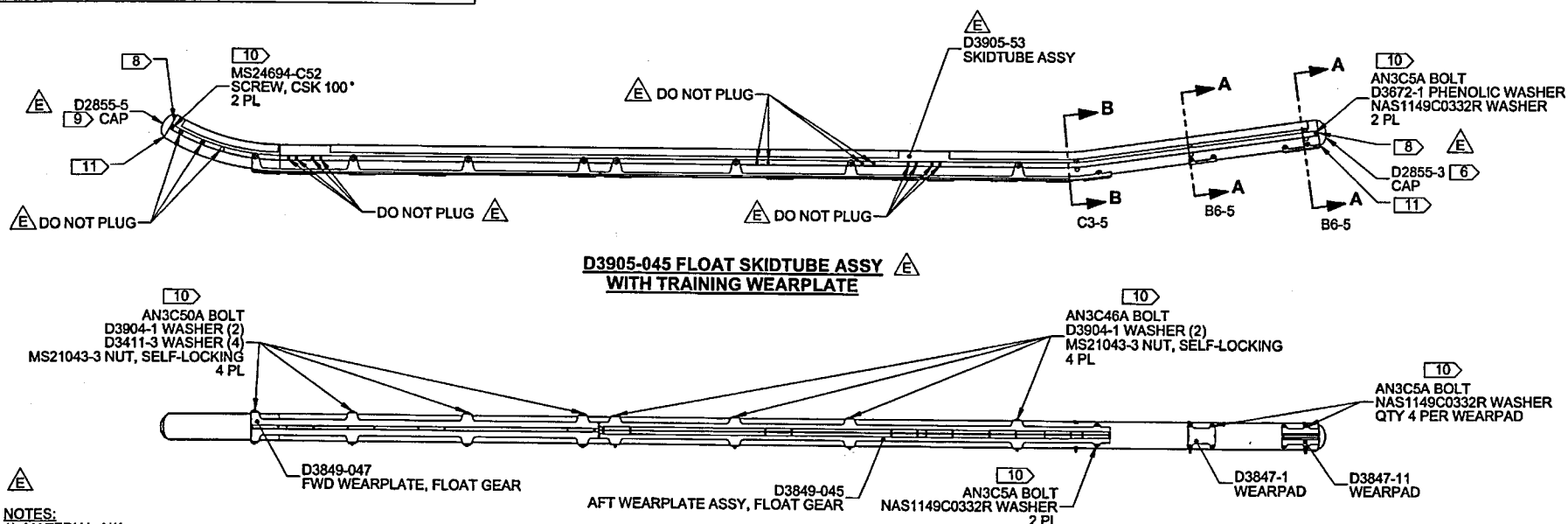
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DESIGN	AJS	DART AEROSPACE USA, INC.	
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CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3905	SHEET 2 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 FLOAT SKIDTUBE ASSY	NTS
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ITEM	QTY -045	P/N	DESCRIPTION
	X	D3905-045	FLOAT SKIDTUBE ASSY
1	1	D2855-3	CAP
2	1	D2855-5	CAP
3	16	D3411-3	WASHER
4	2	D3672-1	PHENOLIC WASHER
5	1	D3847-1	WEARPAD
6	1	D3847-11	WEARPAD
7	1	D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
8	1	D3849-047	FWD WEARPLATE, FLOAT GEAR
9	18	D3904-1	WASHER
10	1	D3905-053	SKIDTUBE SUB ASSEMBLY
11	2	D5101-041	CROSSBOLT SPACER ASSY
12	1	D5101-047	CROSS BOLT SPACER
13	6	D5101-3	INSERT
14	6	D5101-5	INSERT

ITEM	QTY -045	P/N	DESCRIPTION
15	1	ALS4-1032-225	INSERT
16	12	AN3C5A	BOLT
17	4	AN3C46A	BOLT
18	4	AN3C50A	BOLT
19	3	AN4C46A	BOLT
20	8	MS21043-3	NUT, SELF-LOCKING
21	3	MS21043-4	NUT, SELF-LOCKING
22	2	MS24694-C52	SCREW, CSK 100°
15	12	NAS1149C0332R	WASHER
24	6	NAS1149D0416J	WASHER



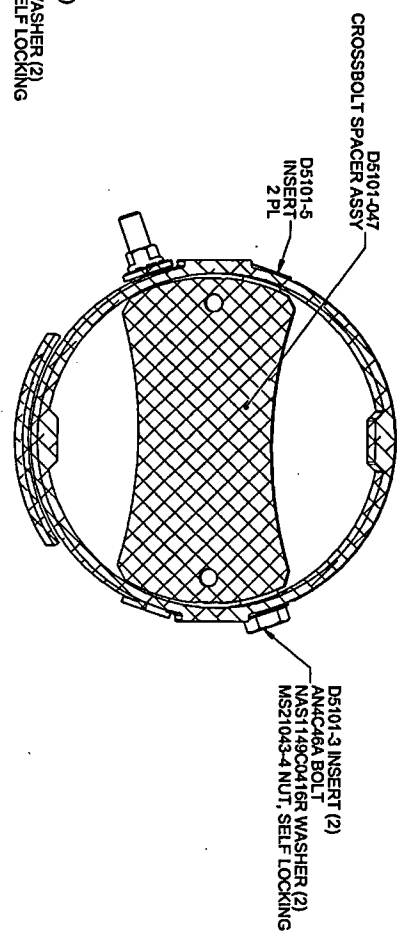
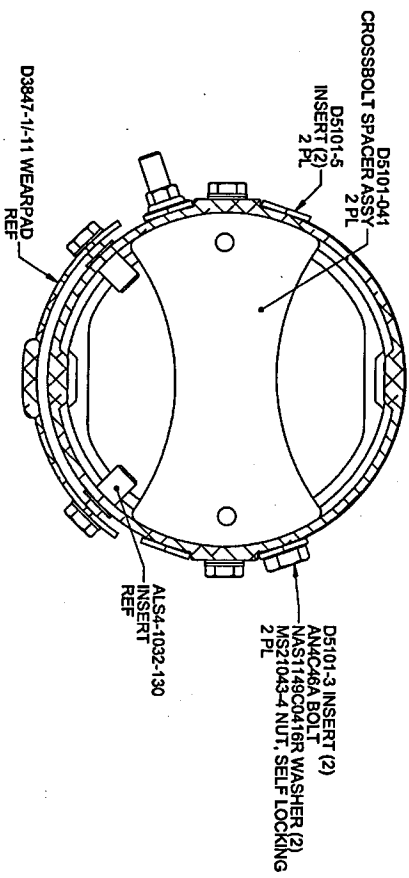
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3905-045" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 48.0 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
- 9) USE D3905-053 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP, OPEN HOLE TO $\phi 0.297$, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

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MFG. APPR.	DD	D3905	SHEET 4 OF 14
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DE APPR.	DS	A119 FLOAT SKIDTUBE ASSY	NTS
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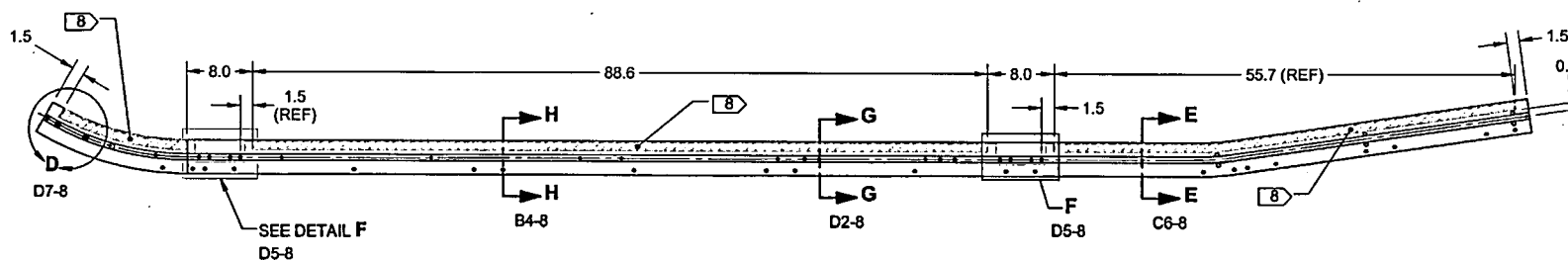


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APPROVED	HS	TITLE
DE APPR.	DE	A119 FLOAT SKIDTUBE ASSY
DATE	17.03.13	SCALE
		NTS

COMMENTS: 1. 2. 3. 4. 5. 6. 7. 8. 9. 10. 11. 12. 13. 14. 15. 16. 17. 18. 19. 20. 21. 22. 23. 24. 25. 26. 27. 28. 29. 30. 31. 32. 33. 34. 35. 36. 37. 38. 39. 40. 41. 42. 43. 44. 45. 46. 47. 48. 49. 50. 51. 52. 53. 54. 55. 56. 57. 58. 59. 60. 61. 62. 63. 64. 65. 66. 67. 68. 69. 70. 71. 72. 73. 74. 75. 76. 77. 78. 79. 80. 81. 82. 83. 84. 85. 86. 87. 88. 89. 90. 91. 92. 93. 94. 95. 96. 97. 98. 99. 100. 101. 102. 103. 104. 105. 106. 107. 108. 109. 110. 111. 112. 113. 114. 115. 116. 117. 118. 119. 120. 121. 122. 123. 124. 125. 126. 127. 128. 129. 130. 131. 132. 133. 134. 135. 136. 137. 138. 139. 140. 141. 142. 143. 144. 145. 146. 147. 148. 149. 150. 151. 152. 153. 154. 155. 156. 157. 158. 159. 160. 161. 162. 163. 164. 165. 166. 167. 168. 169. 170. 171. 172. 173. 174. 175. 176. 177. 178. 179. 180. 181. 182. 183. 184. 185. 186. 187. 188. 189. 190. 191. 192. 193. 194. 195. 196. 197. 198. 199. 200. 201. 202. 203. 204. 205. 206. 207. 208. 209. 210. 211. 212. 213. 214. 215. 216. 217. 218. 219. 220. 221. 222. 223. 224. 225. 226. 227. 228. 229. 230. 231. 232. 233. 234. 235. 236. 237. 238. 239. 240. 241. 242. 243. 244. 245. 246. 247. 248. 249. 250. 251. 252. 253. 254. 255. 256. 257. 258. 259. 260. 261. 262. 263. 264. 265. 266. 267. 268. 269. 270. 271. 272. 273. 274. 275. 276. 277. 278. 279. 280. 281. 282. 283. 284. 285. 286. 287. 288. 289. 290. 291. 292. 293. 294. 295. 296. 297. 298. 299. 300. 301. 302. 303. 304. 305. 306. 307. 308. 309. 310. 311. 312. 313. 314. 315. 316. 317. 318. 319. 320. 321. 322. 323. 324. 325. 326. 327. 328. 329. 330. 331. 332. 333. 334. 335. 336. 337. 338. 339. 340. 341. 342. 343. 344. 345. 346. 347. 348. 349. 350. 351. 352. 353. 354. 355. 356. 357. 358. 359. 360. 361. 362. 363. 364. 365. 366. 367. 368. 369. 370. 371. 372. 373. 374. 375. 376. 377. 378. 379. 380. 381. 382. 383. 384. 385. 386. 387. 388. 389. 390. 391. 392. 393. 394. 395. 396. 397. 398. 399. 400. 401. 402. 403. 404. 405. 406. 407. 408. 409. 410. 411. 412. 413. 414. 415. 416. 417. 418. 419. 420. 421. 422. 423. 424. 425. 426. 427. 428. 429. 430. 431. 432. 433. 434. 435. 436. 437. 438. 439. 440. 441. 442. 443. 444. 445. 446. 447. 448. 449. 450. 451. 452. 453. 454. 455. 456. 457. 458. 459. 460. 461. 462. 463. 464. 465. 466. 467. 468. 469. 470. 471. 472. 473. 474. 475. 476. 477. 478. 479. 480. 481. 482. 483. 484. 485. 486. 487. 488. 489. 490. 491. 492. 493. 494. 495. 496. 497. 498. 499. 500. 501. 502. 503. 504. 505. 506. 507. 508. 509. 510. 511. 512. 513. 514. 515. 516. 517. 518. 519. 520. 521. 522. 523. 524. 525. 526. 527. 528. 529. 530. 531. 532. 533. 534. 535. 536. 537. 538. 539. 540. 541. 542. 543. 544. 545. 546. 547. 548. 549. 550. 551. 552. 553. 554. 555. 556. 557. 558. 559. 560. 561. 562. 563. 564. 565. 566. 567. 568. 569. 570. 571. 572. 573. 574. 575. 576. 577. 578. 579. 580. 581. 582. 583. 584. 585. 586. 587. 588. 589. 590. 591. 592. 593. 594. 595. 596. 597. 598. 599. 600. 601. 602. 603. 604. 605. 606. 607. 608. 609. 610. 611. 612. 613. 614. 615. 616. 617. 618. 619. 620. 621. 622. 623. 624. 625. 626. 627. 628. 629. 630. 631. 632. 633. 634. 635. 636. 637. 638. 639. 640. 641. 642. 643. 644. 645. 646. 647. 648. 649. 650. 651. 652. 653. 654. 655. 656. 657. 658. 659. 660. 661. 662. 663. 664. 665. 666. 667. 668. 669. 670. 671. 672. 673. 674. 675. 676. 677. 678. 679. 680. 681. 682. 683. 684. 685. 686. 687. 688. 689. 690. 691. 692. 693. 694. 695. 696. 697. 698. 699. 700. 701. 702. 703. 704. 705. 706. 707. 708. 709. 710. 711. 712. 713. 714. 715. 716. 717. 718. 719. 720. 721. 722. 723. 724. 725. 726. 727. 728. 729. 730. 731. 732. 733. 734. 735. 736. 737. 738. 739. 740. 741. 742. 743. 744. 745. 746. 747. 748. 749. 750. 751. 752. 753. 754. 755. 756. 757. 758. 759. 760. 761. 762. 763. 764. 765. 766. 767. 768. 769. 770. 771. 772. 773. 774. 775. 776. 777. 778. 779. 780. 781. 782. 783. 784. 785. 786. 787. 788. 789. 790. 791. 792. 793. 794. 795. 796. 797. 798. 799. 800. 801. 802. 803. 804. 805. 806. 807. 808. 809. 810. 811. 812. 813. 814. 815. 816. 817. 818. 819. 820. 821. 822. 823. 824. 825. 826. 827. 828. 829. 830. 831. 832. 833. 834. 835. 836. 837. 838. 839. 840. 841. 842. 843. 844. 845. 846. 847. 848. 849. 850. 851. 852. 853. 854. 855. 856. 857. 858. 859. 860. 861. 862. 863. 864. 865. 866. 867. 868. 869. 870. 871. 872. 873. 874. 875. 876. 877. 878. 879. 880. 881. 882. 883. 884. 885. 886. 887. 888. 889. 890. 891. 892. 893. 894. 895. 896. 897. 898. 899. 900. 901. 902. 903. 904. 905. 906. 907. 908. 909. 910. 911. 912. 913. 914. 915. 916. 917. 918. 919. 920. 921. 922. 923. 924. 925. 926. 927. 928. 929. 930. 931. 932. 933. 934. 935. 936. 937. 938. 939. 940. 941. 942. 943. 944. 945. 946. 947. 948. 949. 950. 951. 952. 953. 954. 955. 956. 957. 958. 959. 960. 961. 962. 963. 964. 965. 966. 967. 968. 969. 970. 971. 972. 973. 974. 975. 976. 977. 978. 979. 980. 981. 982. 983. 984. 985. 986. 987. 988. 989. 990. 991. 992. 993. 994. 995. 996. 997. 998. 999. 1000.

ITEM	QTY	P/N	DESCRIPTION
	X	D3905-051	SKIDTUBE SUB ASSY
1	2	D2579	CROSS BOLT SPACER
2	8	D3681-1	SPACER
3	12	D3903-1	SPACER
4	1	D3905-061	SKIDTUBE SUB ASSEMBLY
5	42	ALS4-1032-130	INSERT



D3905-051 SKIDTUBE SUB ASSEMBLY

NOTES:

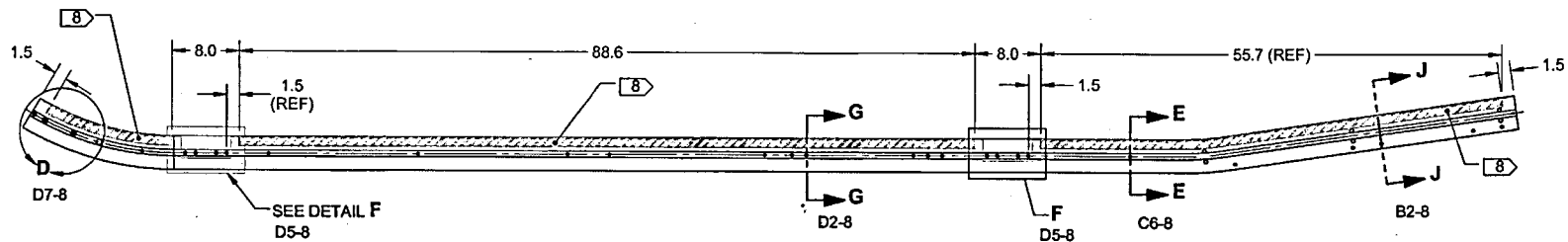
- 1) MATERIAL: N/A
- 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: N/A
- 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50" ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

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2017-05-08

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DESIGN	AJS	DART AEROSPACE USA, INC.	
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CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3905	SHEET 6 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 FLOAT SKIDTUBE ASSY	NTS
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ITEM	QTY	P/N	DESCRIPTION
	X	D3905-053	SKIDTUBE SUB ASSY
1	2	D2579	CROSS BOLT SPACER
2	8	D3681-1	SPACER
3	12	D3903-1	SPACER
4	1	D3905-063	SKIDTUBE SUB ASSEMBLY
5	10	ALS4-1032-130	INSERT



D3905-053 SKIDTUBE SUB ASSEMBLY

NOTES:

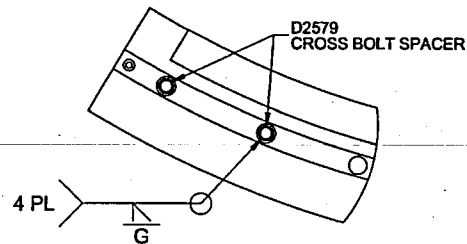
- 1) MATERIAL: N/A
- 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: N/A
- 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50" ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

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2017-05-08

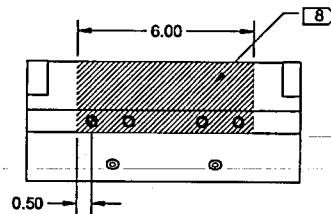
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DESIGN	AJS	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	WK		
CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3905	SHEET 7 OF 14
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DE APPR.	DS	A119 FLOAT SKIDTUBE ASSY	NTS
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8 7 6 5 4 3 2 1



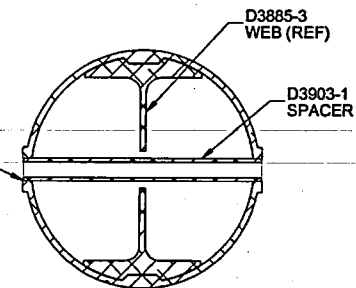
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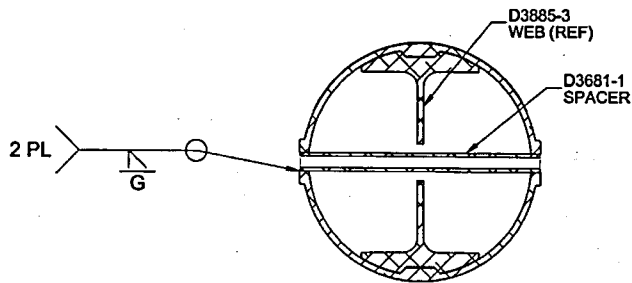
DETAIL F
SCALE: 3.5X

2 PL

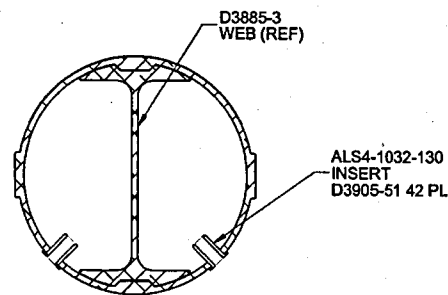
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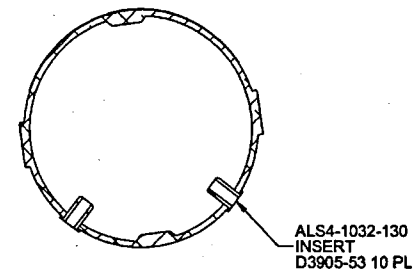
SECTION G-G
SCALE: 7X
12 PL



SECTION E-E
SCALE: 7X
8 PL



SECTION H-H
SCALE: 7X
D3905-51 21 PL



SECTION J-J
SCALE: 7X
D3905-53 10 PL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) MASK THIS AREA AND DO NOT APPLY PRIMER OR PAINT
- 9) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION G-G $\phi 0.375$ HOLES ONLY:
 - i) CHAMFER HOLES $\phi 0.475 \times 45^\circ$
 - ii) INSERT D3903-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) CBORE TO $\phi 0.313 \times 0.75$ DEEP
 - v) DEBURR HOLES
- 10) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION E-E $\phi 0.313$ HOLES ONLY:
 - i) CHAMFER HOLES $\phi 0.354 \times 45^\circ$ OR 0.050 DEEP $\times 45^\circ$ (BOTH SIDES)
 - ii) INSERT D3681-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) DEBURR HOLES
- 11) WELD PER DART QSI 004

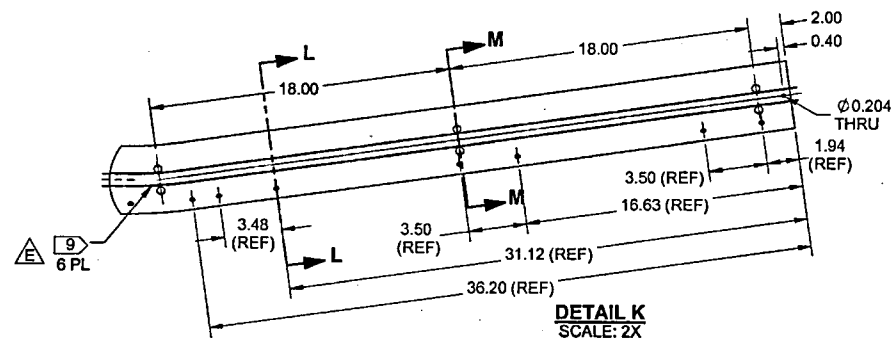
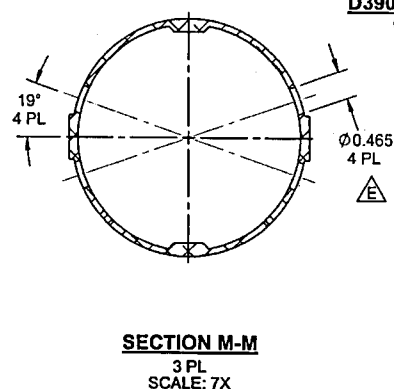
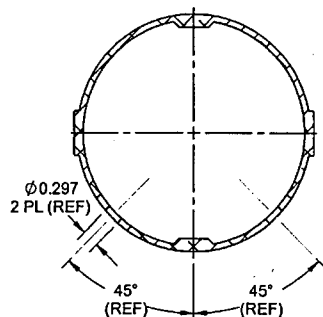
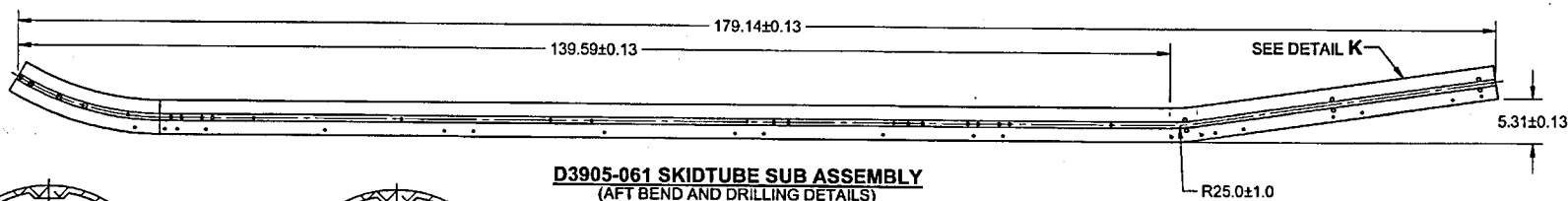
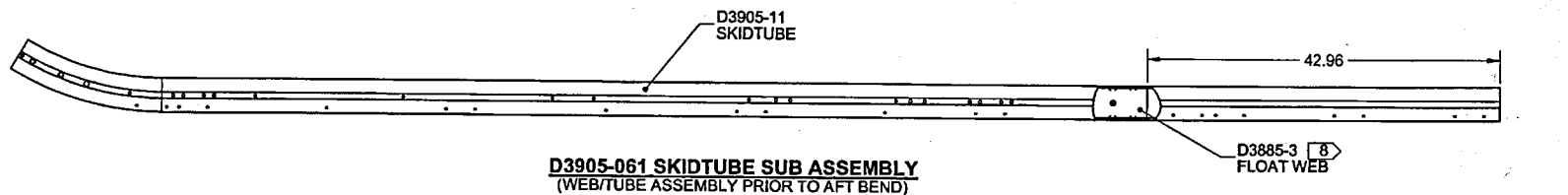
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2017-05-08

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DESIGN	AJS	DART AEROSPACE USA, INC.	
DRAWN	WK	EUGENE, OR	
CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3905	SHEET 8 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	D3	A119 FLOAT SKIDTUBE ASSY	NTS
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8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
		D3905-061	SKIDTUBE SUB ASSEMBLY
1	1	D3885-3	FLOAT WEB
2	1	D3905-11	SKIDTUBE



NOTES:

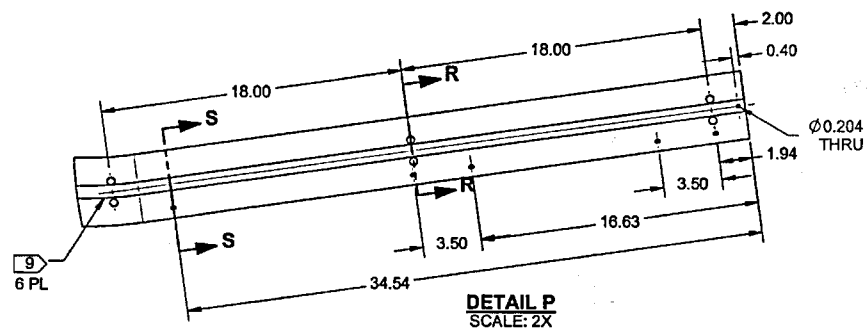
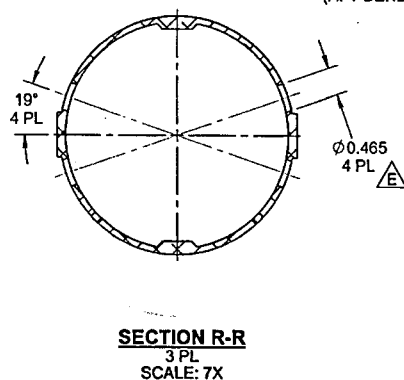
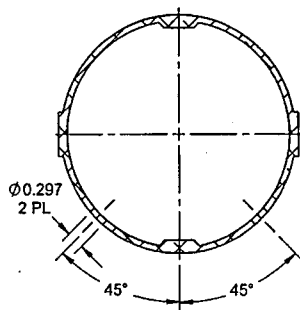
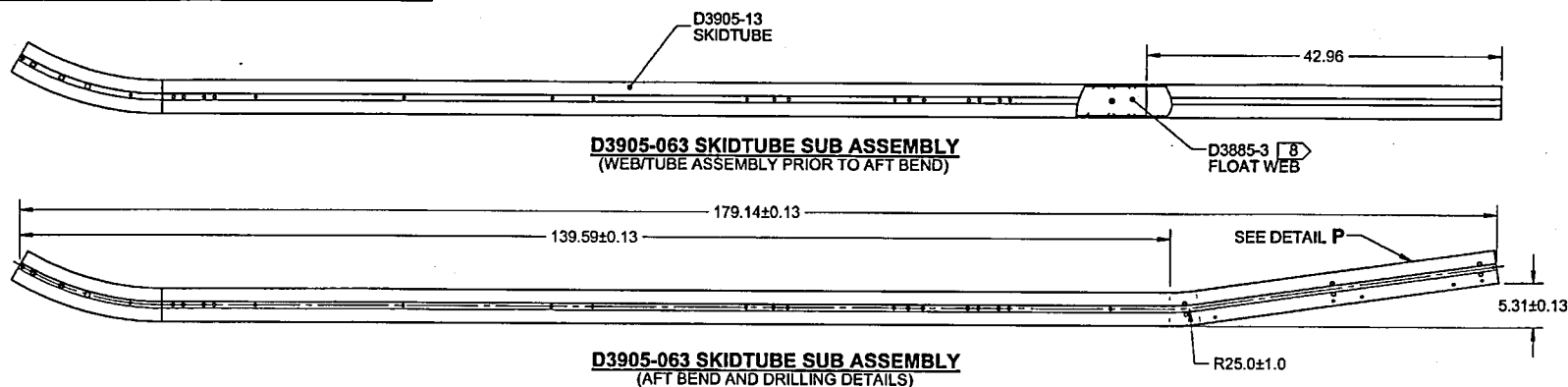
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING. ENSURE HOLES LINE-UP
- 9) RELIEVE RIDGE FLUSH WITH SKIDTUBE FOR INSERT CLEARANCE, MAX 0.130 INTO RIDGE

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DE APPR.	DS	A119 FLOAT SKIDTUBE ASSY	NTS
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ITEM	QTY	P/N	DESCRIPTION
	X	D3905-063	SKIDTUBE SUB ASSEMBLY
1	1	D3885-3	FLOAT WEB
2	1	D3905-13	SKIDTUBE



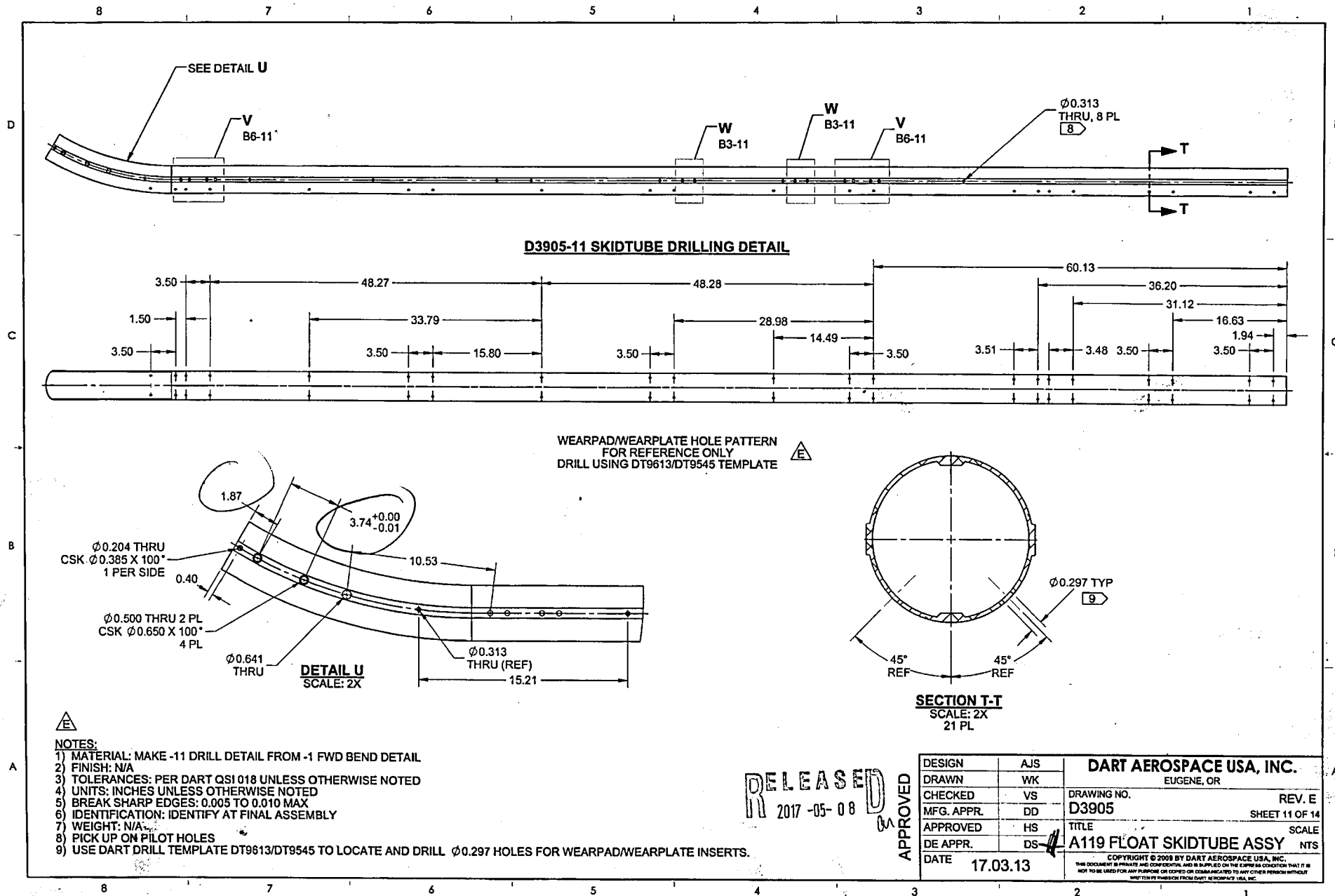
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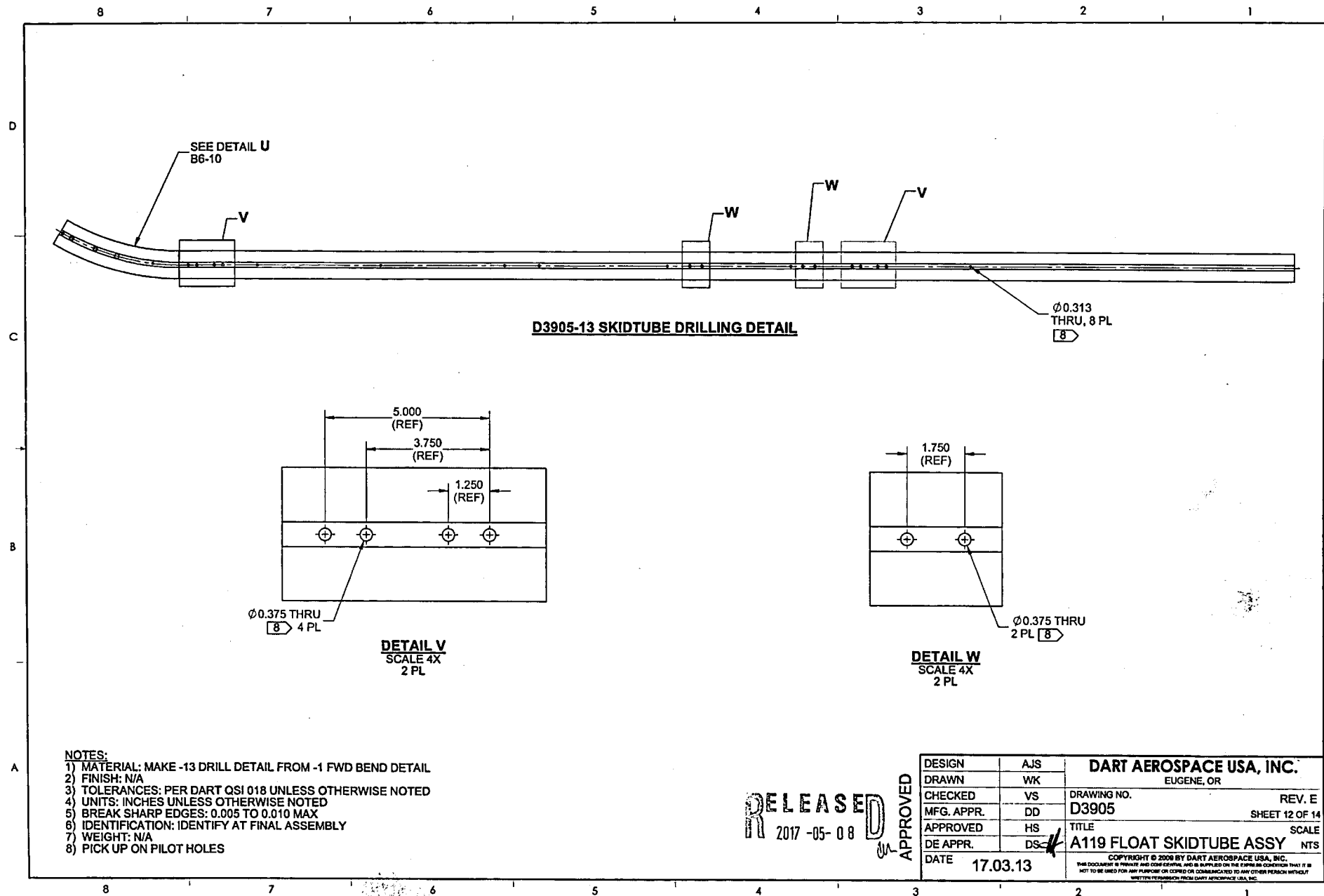
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING. ENSURE HOLES LINE-UP
- 9) RELIEVE RIDGE FLUSH WITH SKIDTUBE FOR INSTERT CLEARANCE, MAX 0.130 INTO RIDGE

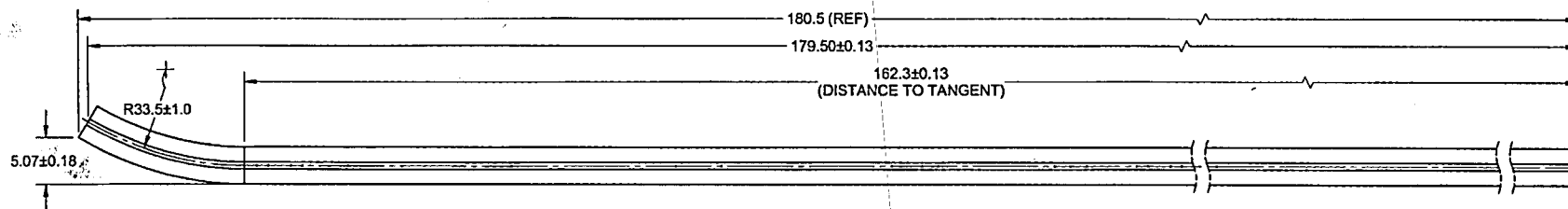
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MFG. APPR.	DD	D3905	SHEET 10 OF 14
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DE APPR.	DS	A119 FLOAT SKIDTUBE ASSY	NTS
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D3905-1 SKIDTUBE FWD BEND DETAIL

NOTES:

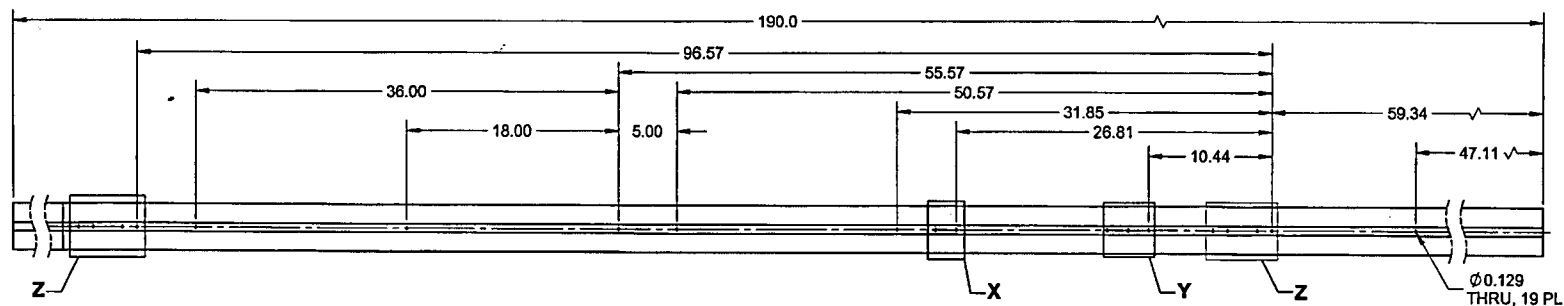
- 1) MATERIAL: MAKE -1 FWD BEND DETAIL FROM -3 PILOT HOLE DETAIL
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A

8) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

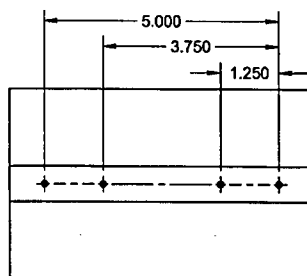
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2017-05-08

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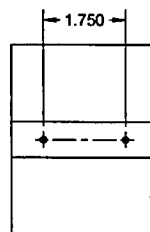
DESIGN	AJS	DART AEROSPACE USA, INC.	
DRAWN	WK	EUGENE, OR	
CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3905	SHEET 13 OF 14
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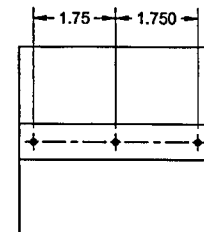
D3905-3 SKIDTUBE PILOT HOLE DETAIL



DETAIL Z
SCALE: 4X



DETAIL X
SCALE: 4X



DETAIL Y
SCALE: 4X

NOTES:

- 1) MATERIAL: MAKE FROM D2500-1-190 EXTRUSION
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A

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MFG. APPR.	DD	D3905	SHEET 14 OF 14
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039334**

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO039334
PO Date: 3/16/18
Due Date: 3/29/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	173805	D3413-1BL	O-Ring SPRAY PAINT BLUE BATCH: _____	Firmed	3/29/18	6 pcs	0 pcs	6 pcs	\$15.00/pcs	\$90.00
2	171306	D350-636-012	Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.	Firmed	3/29/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
3	173151	D350-636-011	Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.	Firmed	3/29/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
4	172347	D350-636-012	Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.	Firmed	3/29/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
5	173337	D119-646-043	AW119 Replacement Skidtube with Wearpads, Float Compatible - Fits LH or RH	Firmed	3/29/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
6	172659	D3391-023	Mid Tube Assembly	Firmed	3/29/18	1 pcs	0 pcs	1 pcs	\$125.00/pcs	\$125.00
7	172661	D3391-023	Mid Tube Assembly	Firmed	3/29/18	1 pcs	0 pcs	1 pcs	\$125.00/pcs	\$125.00
8	172662	D3391-023	Mid Tube Assembly	Firmed	3/29/18	1 pcs	0 pcs	1 pcs	\$125.00/pcs	\$125.00
9	172658	D3391-023	Mid Tube Assembly	Firmed	3/29/18	1 pcs	0 pcs	1 pcs	\$125.00/pcs	\$125.00
Grand Total:									\$1,490.00	

Order Notes